

Date: Thursday, 1/17/2008 3:31:38 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GAS SPRING ASSEMBLY
Job Number : 36845	
Estimate Number : 10181	
P.O. Number :	Part Number : D2153
This Issue : 1/17/2008 S.O. No. :	Drawing Number : D2153 REV. A1
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : PURCHASED PARTS	Drawing Revision : A1
Previous Run : 29047	Material :
Written By :	Due Date : 1/31/2008 Qty: 36 Um: Each
Checked & Approved By : <u>08 01 18</u>	
Comment : Est: E 02.07.08 Re-format KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 5487

Gas Spring P/N: SL13-10 (10lb)

Possible supplier: Spring Lift Corporation

Note: Do not ship by air**

Allow an extra 7 to 10 business days for shipping**

Material release note is required

08 10 11 18

~~36~~ (36)

2.0	D2153P	Door Prop
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
GAS SPRING ASSEMBLY

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

08 11 28

(36)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect Test Spring is 10lb

08 11 29 (36)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 36845

Part Number: D2153

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D30153

Lock Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Lock Nut

Pick:

Qty Part Number

Description

Batch

2 D3015-3

Lock nut

35479

72

6.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

2 AN960JD516

Washer

1106167

72

7.0

SL69BS

Ball Stud



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Ball Stud

Pick:

Qty Part Number

Description

Batch

2 SL69-BS

Stud

102458 64X M106939 8X

24.1/30

36

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D2153

2- Remove Spring Lift name and address with Acetone, leave only warning:

"DO NOT OPEN HIGH PRESSURE"

08/01/30 (36)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/30 (36)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST439

08/02/01 (36)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 02/02/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 36845

Part Number: D2153

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



(36)

Comment: FINAL INSPECTION/W/O RELEASE

2008/02/04

Job Completion



in 2008/2/04 (36)

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

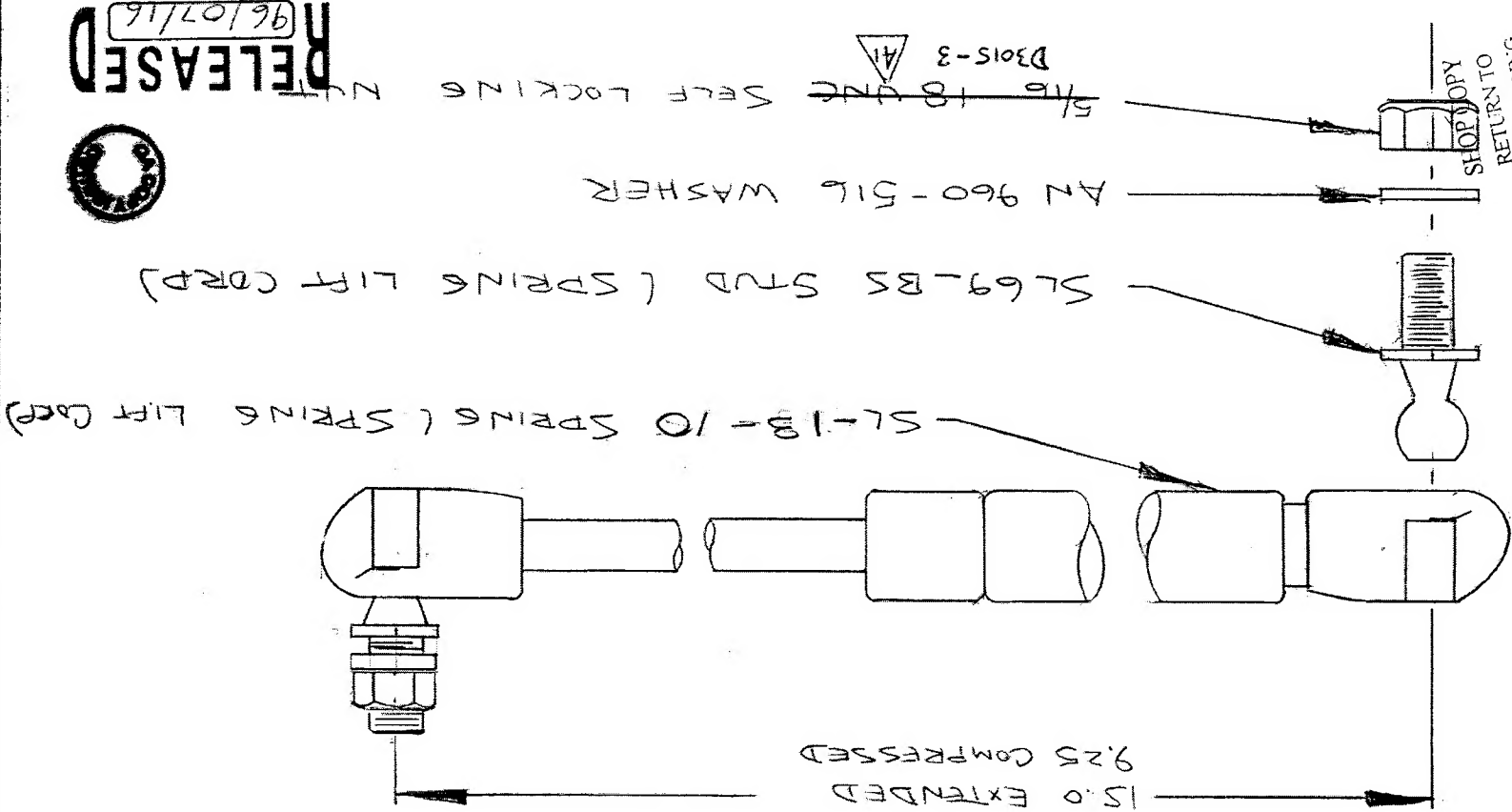
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

UNCONTROLLED COPY
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
36845
NO.



RELEASED 96/07/16



DZ153

attwood**SWIVL-EZE**

TELEPHONE: 616-897-2290

CUST: 68530 MST: 90173-00

BILL TO: DART AERO LTD.
REQ: 01/22/08

COLLECT 151793240

PRO NO: 778104318
SHIP VIA: FEDEX GROUND
BOL: 00226970000933232

F ATTWOOD / SWIVL-EZE

FREIGHT: _____

O 1016 NORTH MONROE

M LOWELL MI 49331-0260

T DART AERO LTD.
O 1270 ABERDEEN STREET

HAWKESSURY ON K6A 1K7

CRTS: / ☒ PO#: 5487

WGT: 15 DATE: 01/24/08

SPUR: 4

LABEL NO:
4553370524

---ROUTING GUIDE INFO ---

---SHIPPED---

CRTS	QTY	LOCATN	PART#	UPC	DESCRIPTION / SKU	LINE	QTY	WG
1	36	Z09211	EA	SL13-10-1	GS SPRNG 15" EXTC 10# BL	1	36	1
1	100	Z10321	EA	SL69-BE-1	10MM BALL STUO W/THRD	2	100	

===== COMPLETE ===== PICK BY: